

Work Order ID 109948

109948

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December-09-13 7:40:25 AM

Item ID: D3190-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chaffing Shield

Start Date: 12/09/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/23/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12-12-09

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3190

Rev A

100

0.00

100

Waterjet

Memo

0.00

FLOW/CNC Waterjet

CUT AS PER DWG

DWG REV: APROG REV: A

304 24GA.

14 0 Jm 14-1-5

105

QC2- Inspect parts off machine FAI/FAIB

0.00

105

QC

Memo

0.00

Quality Control

14 0 Jm 14-1-5

106

QC8- Inspect parts - second check

0.00

106

QC

Memo

0.00

Quality Control

DAS
27
9-89
14/1/814

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

DAS
36
9-89

14/01/05

Roll as per Dwg D3190

DAS
27
9-89

9-89
14/1/9

Quality Control

14

0.00

Packaging

As
14-1-13

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Item ID: D3190-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Chaffing Shield

Start Date: 12/09/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/23/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

14-01-13

14-01-13

Picklist Print

Page 1

December-09-13 7:40:28 AM

Work Order ID: 109948

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Parent Item: D3190-1

D3190-1

Parent Item Name: Chaffing Shield

Start Date: 12/09/13

Required Date: 12/23/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A03.05.26New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased		No		100	sf	0.0000	0.2153	4			

M304S25GA

304/316 .020" Sheet

**

4 sq Ft.

Jm 14-1-5

M304S 24 GA

M304S24GA MTL

ACCEPTABLE

A.P.

14.01.08

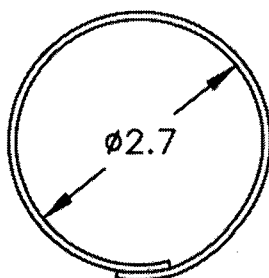
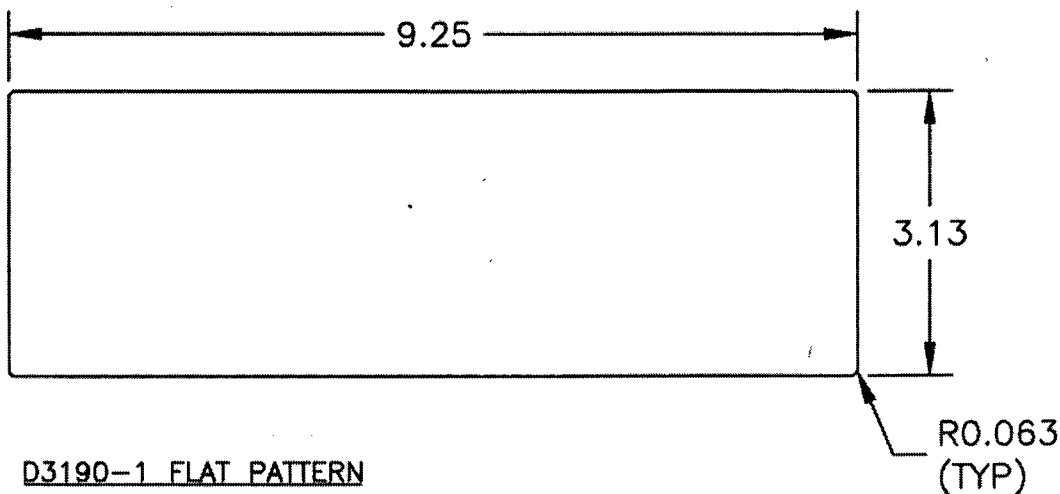
B# 125771

125771



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22 #



D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

109948 MLS
(3-12-09)

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